

Date: Wednesday, 27/02/2008 7:40:22 AM
 User: Linda Lacelle

Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	BRACKET L/H
Job Number	37635		Part Number	D30721
Estimate Number	11549		Drawing Number	D3072 REV A1
P.O. Number	:		Project Number	N/A
This Issue	27/02/2008	S.O. No. :	Drawing Revision	A1
Prsht Rev.	NC		Material	:
First Issue	/ /	Type : SMALL /MED FAB	Due Date	14/03/2008
Previous Run	37635		Qty:	20
Written By	:		Um:	Each
Checked & Approved By	:			
Comment	Est. B02.01.18	Flat pattern created on dash 101. NG		
	Est Rev.C	08-02-26 now water jet DD verified by:LL		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M5052H32S090	5052-H32 .090 Sheet
		3
	Comment: Qty.: 0.1225 sf(s)/Unit Total : 2.4507 sf(s)	
	5052-H32 .090 Sheet	
	Batch 3019 B 8-2-27	
2.0	WATER JET	FLOW WATER JET
	Comment: FLOW WATER JET	
	1-Cut as per Dwg D3072 (D3072-101 flat pattern)	
	Dwg Rev: A1	18 8-2-27
	Prog Rev: A1	22
	2-Deburr if necessary	B 8-2-27
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	Comment: SMALL & MEDIUM FAB RESOURCE 1	
	1- deburr if necessary	B 08/03/04 21
	2- Bend as per dwg D3072	8B 08/03/03

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET L/H

Job Number: 37635

Part Number: D30721

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



08/03/06 (21)

Comment: INSPECT WORK TO CURRENT STEP

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

08-03-05

(21)

8.0 POWDER COATING

POWDER COATING



M100700

(21)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M-1 08/03/06

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(21)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 08-03-06

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5563

08/03 (21)

11.0 QC21

FINAL INSPECTION/W/O RELEASE



(21)

Comment: FINAL INSPECTION/W/O RELEASE

08/03/06

Job Completion



2008/3/06

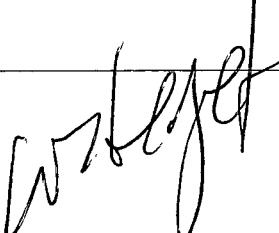
(21)

Date: Tuesday, 2/26/2008 8:02:16 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BRACKET		
Job Number	: 37635					
Estimate Number	: 11549					
P.O. Number	:			Part Number	: D30721	
This Issue	: 2/26/2008		S.O. No.	: D3072 REV A1		
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type	: SMALL /MED FAB		
Previous Run	:			Drawing Revision	: A1	
Written By	:			Material	:	
Checked & Approved By	:			Due Date	: 3/14/2008	
Comment	: Est. B 02.01.18 Flat pattern created on dash 101. NG			Qty:	20	Um: Each

Additional Product

Job Number:					
Seq. #:	Machine Or Operation:	Description :			
1.0	D3072101	Bracket (flat)			
					
Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)					
Bracket (flat)					
Pick:					
Qty	Part Number	Description	Batch		
1	D3072-101	Bracket			
2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1			
					
Comment: SMALL & MEDIUM FAB RESOURCE 1					
Bend as per dwg D3072					
Dash 1 bending detail(LH)					
3.0	QC5	INSPECT WORK TO CURRENT STEP			
					
Comment: INSPECT WORK TO CURRENT STEP					
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1			
					
Comment: HAND FINISHING RESOURCE #1					
Chemical Conversion Coat as per QSI 005 4.1					
5.0	POWDER COATING	POWDER COATING			
					
Comment: POWDER COATING					
Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/03/04	5	I part, was out of tolerance Hence error	08/04/04	Scrap + destroy W/O replace	SA 08/03/04	08/03/04	08/03/04	08/03/04

NOTE: Date & initial all entries

Date: Tuesday, 2/26/2008 8:02:16 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 37635

Part Number: D30721

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

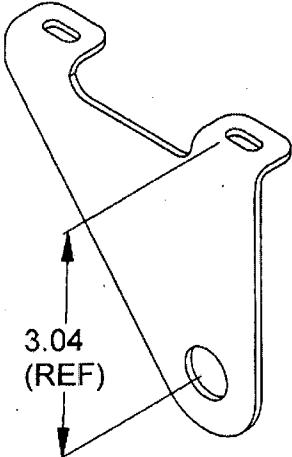
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



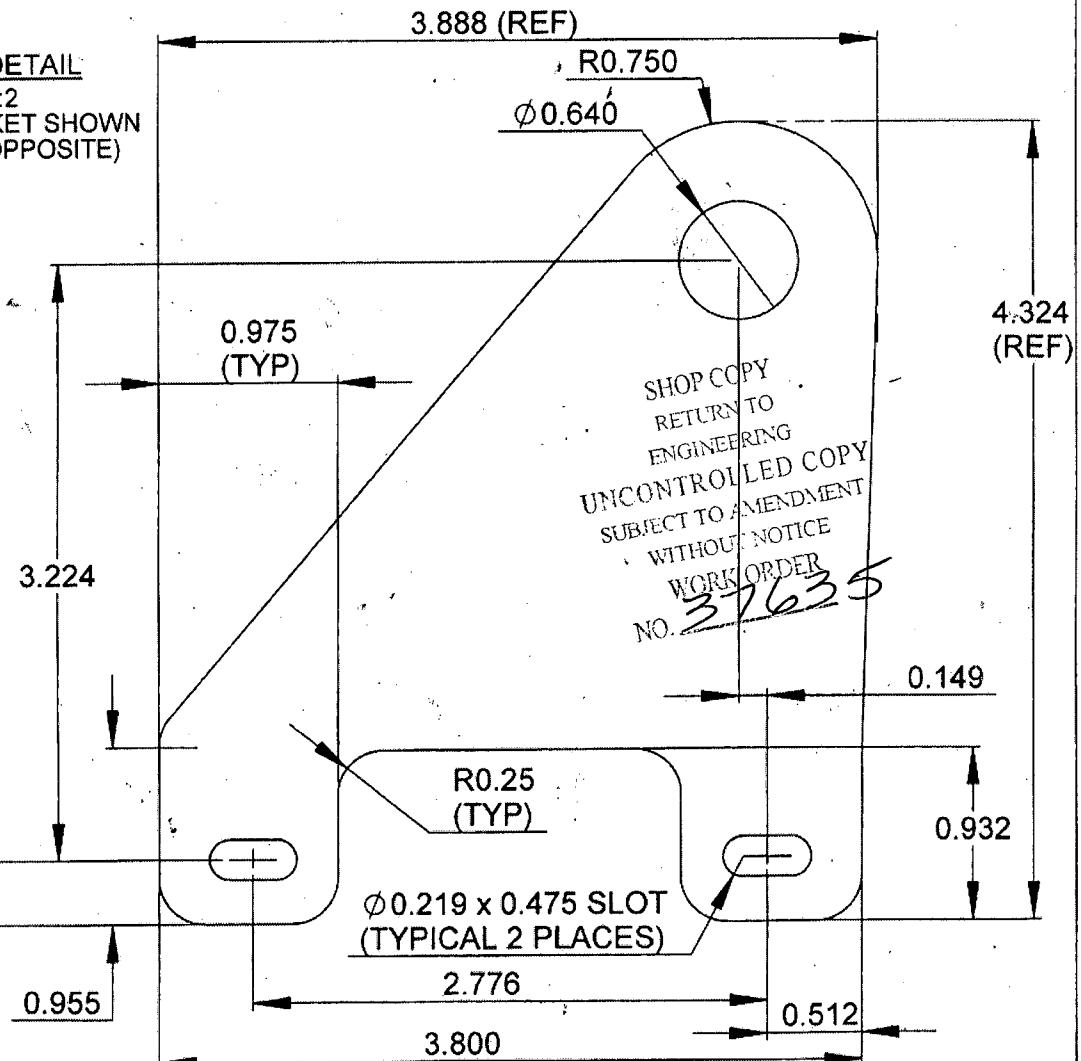
DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>HL</i>	APPROVED <i>CH</i>	DRAWING NO. D3072	REV. A SHEET 1 OF 1	
DATE 01.12.16		TITLE BRACKET	SCALE 1:1	
A	01.12.16	NEW ISSUE		



BENDING DETAIL
SCALE 1:2
D3072-1 LH BRACKET SHOWN
(D3072-2 BEND OPPOSITE)

D3072-1/-2 BRACKET

- 1) MATERIAL: 5052-H32/H34 (AMS 4016/4017/
QQ-A-250/8) 0.090 THICK.
- 2) FINISH: POWDER COATBLACK SANTEX (4.3.5.7)
PER DART QSI 005 4.3.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES.



D3072-101

FLAT PATTERN FOR D3072-1/-2

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DART AEROSPACE LTD	Work Order:	37635
Description: BRACKET L/H	Part Number:	D 3072-1
Inspection Dwg: D 3072-1 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>BS</u>	Audited by: <u>/</u>	Prototype Approval: <u>N/A</u>
Date: <u>8-2-27</u>	Date: <u>100227</u>	Date: <u>/</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	